

Date: Monday, 05/03/2007 11:53:47 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30995
Estimate Number : 10326
P.O. Number : N/A
This Issue : 05/03/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 01/03/2007 Type : MACHINED PARTS
Previous Run : 29339
Written By : [Signature]
Checked & Approved By : [Signature]
Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

Drawing Name : LUG EXTRUSION
Part Number : D27317
Drawing Number : D2731 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 03/12/2007 Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)
Lug Extrusion D2423
Batch: B30062

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut D2423 extrusion to .82"
Batch 30062

3.0 PG PURCHASING



Comment: PURCHASING
Issue P/O 30062
Possible Supplier : Metec
Machine per Drwg D2731 Rev.B

07/03/08 (100)
50 - June 12, 2007

Park Redmond

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect for transit damage

07/06/18 (42)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/19 (X42)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



42x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-l

07/06/25

7.0

POWDER COATING

POWDER COATING



18x

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m-l

07/06/30

18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ep 07/07/03 (18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Ep 07/07/03 (18)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



18

Comment: FINAL INSPECTION/W/O RELEASE

Ep 07/07/03

Job Completion



U 07-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/18	7	split to send 8 pcs to outside supplier for print	A	07/06/18	8	U	
07/06/18	7	12 24 pcs	U	07/06/18	24	U	

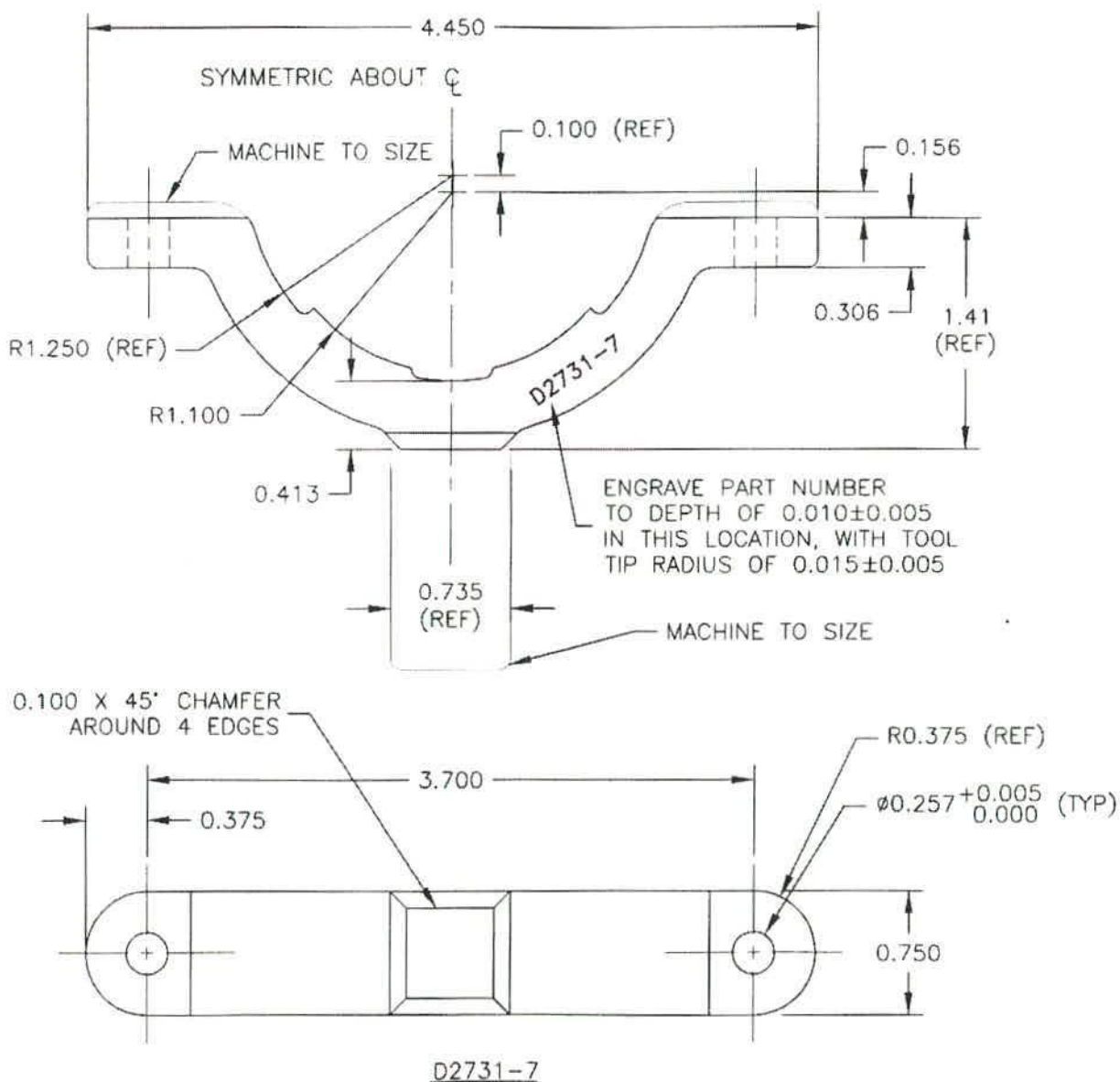
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

69
3.756
- 257
493
3.493